

ABSTRACT OF THE DISCLOSURE

In manufacturing a speaker, ultrasonic complex vibration welding is applied at least to: a process of fixedly putting together a magnet, a pot yoke and the pole piece; a process of fixing, to a portion of an inner circumference of a frame, an outer periphery of a spider, which has its periphery fixed to a bobbin; a process of fixing to a portion of the frame an outer circumferential edge of a surround, which has its inner circumferential edge fixed to an outer periphery of a diaphragm whose inner periphery is fixed to the bobbin; and a process of fixedly connecting both ends of each of tinsel leads respectively to terminations of a voice coil and to terminals.